

Work Order ID 86208

June-22-12 3:05:07 PM

86208

Page 1

Item ID: D4073-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Door Hinge

Start Date: 22/06/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 06/07/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/12 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4073

B

100

Cut blanks as per folio

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

cut blank 4.563" long

RT 12-06-01 (x12)

105

0.00

105

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Mill as per Dwg an Folio FA939

Dwg Rev: B

Folio Rev: AA

RT 12-06-04 (x12)

Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86208

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Page 2

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Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

12-08-14 (x12)

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

SL 12-08-14

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

12 Nov 12 8:13

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

86208

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 22/06/2012 **Start Qty:** 12.00 ***12***

Cust Item ID:

Required Date: 06/07/2012 **Req'd Qty:** 12.00 ***12***

Customer:

Reference:

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start	*NR1*
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____		Stop	*NR2*

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00 Start Time = 2:15

0.00 Temp = 32.0 °F

Finish Time: 2:45

160

Powdercoat

Memo

Powder Coating

W121841

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

12x d M nlog15

Identify as per dwg & Stock Location: 091

0.00

180

Packaging

Memo

0.00

Packaging

8²⁵ 12/08/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-22-12 3:05:11 PM

Page 1

Work Order ID: 86208

86208

Parent Item: D4073-1

D4073-1

Parent Item Name: Door Hinge

Start Date: 22/06/2012

Required Date: 06/07/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A NEW ISSUE 10-06-08 JLM VERIFIED BY:DD IPP
REV:B DRAWING REV. CHANGE AS PER ECN 11-598 11-07-05 JFS
VERIFIED BY:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X01.25 0		Purchased	No			100	f	10.8001	0.38	4.8			

M6061T6B2 000X01 250
6061-T6 Bar 2.00 x 1.25

M122321

**

8. 12-08-01

Location	Loc Qty	Loc Code
MAT009	10.8	
121660	10.8	
MAT010	0.00006358	
121040	0.00006358	

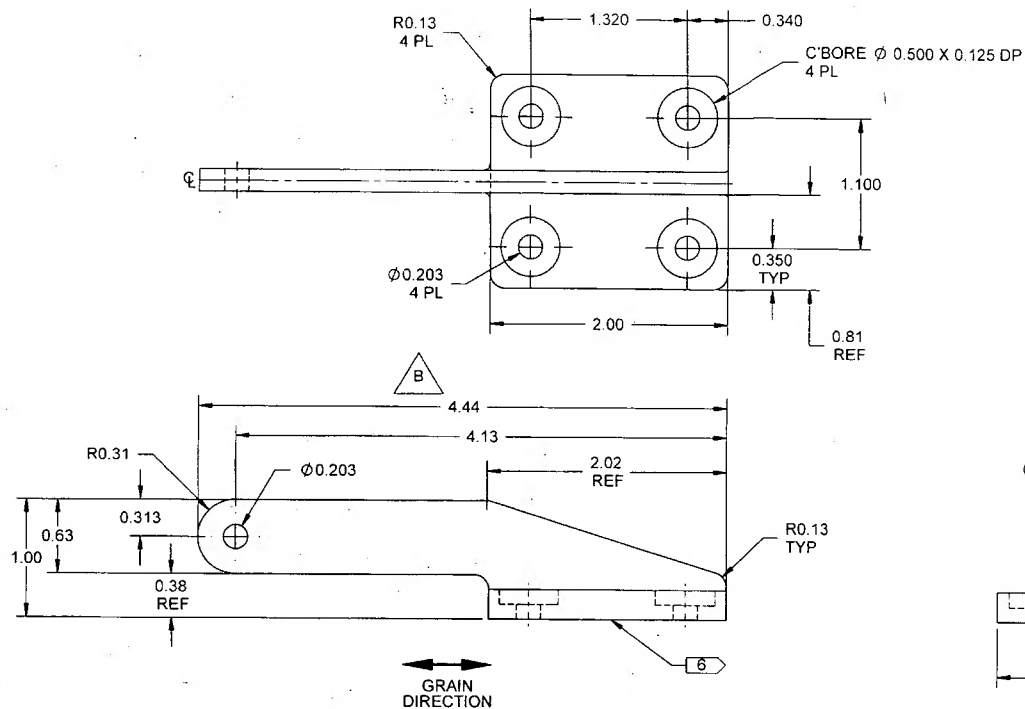
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



D4073-1 DOOR HINGE

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.12 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 06208 MLJ
12/06/22

RELEASED
2011-06-30
NW

B	4.44 WAS 3.75; 4.13 WAS 3.44 (ZN C6-1)	RF	11.05.02
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.05.02		
DART AEROSPACE USA, INC. PORT HADLOCK, WA DRAWING NO. D4073 TITLE DOOR HINGE REV. B SHEET 1 OF 2 SCALE NTS <small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>			

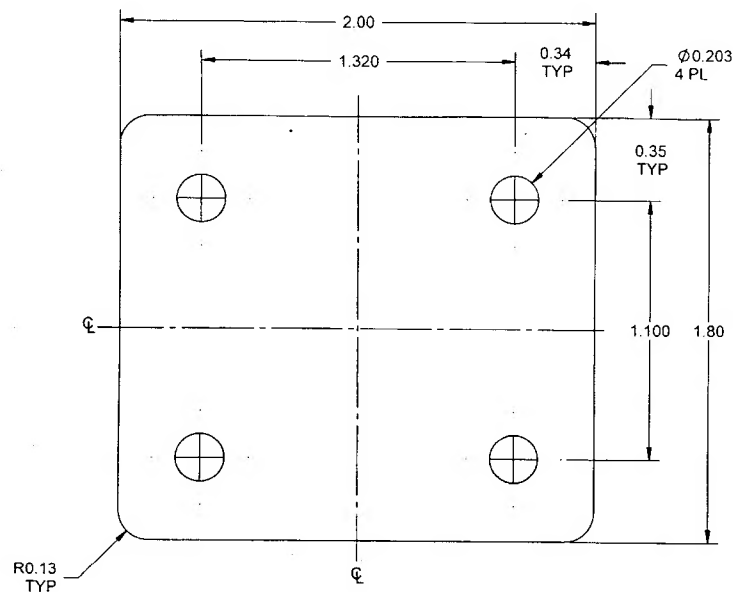
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4073-3 DOOR HINGE BACKING PLATE

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.02 lbs

RELEASED
2011-06-30

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4073	SHEET 2 OF 2
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	DOOR HINGE	NTS
DATE	11.05.02	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	86208
Description: Door Hinge		Part Number:	D4073-1
Inspection Dwg: D4073	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.13	+/-0.030	.130	✓		rad gauge	
Ø0.203	+0.005/-0.001	.204	✓		vern	RT-4
2.00	+/-0.030	2.001	✓		"	
0.81	+/-0.030	.802	✓		depth gauge	RT-6
0.350	+/-0.010	.349	✓		vern	RT-4
1.100	+/-0.010	1.099	✓		"	
Ø0.500 x 0.125	+/-0.010	.502 x .125	✓		"	
0.340	+/-0.010	.34	✓		"	
1.320	+/-0.010	1.319	✓		"	
4.44	+/-0.030	4.433	✓		"	
4.13	+/-0.030	4.123	✓		"	
R0.31	+/-0.030	.310	✓		vern	RT-4
0.313	+/-0.010	.310	✓		"	
0.63	+/-0.030	.619	✓		"	
1.00	+/-0.030	.998	✓		"	
0.38	+/-0.030	.375	✓		depth gauge	RT-6
0.190	+/-0.010	.190	✓		vern	RT-4
1.80	+/-0.030	1.799	✓		"	
0.25	+/-0.030	.250	✓		"	
R0.13	+/-0.030	.130	✓		rad gauge	

Measured by:	SK	Audited by:	SL	Preliminary Approval:	
Date:	12-08-14	Date:	12-08-14	Date:	

Rev	Date	Change	Revised by	Approved
A	11.07.26	New Issue	KJ	MA

W/O:		WORK ORDER CHANGES					
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